



Dart Aerospace Ltd.
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Canada

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D5499-1

Job Sheet 181806



Part No: D5499-1

Job Qty: 8 ea

Part Name: Aft Bracket Mount



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 8/9/18

Job Tracking No:

Due Date: 8/17/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: D5499-1 REV.B IPP REV.A NEW ISSUE 18/04/26 JFS VERIFIED BY:DD IPP REV:B 18/08/03 AS PER DWG
REV.B JFS VERF BY:DP

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	8 Ea	8/17/18	8/17/18	0.00	0.00	Start Up Machining-2		JS
110	CNC Vertical Machining	8 pcs	8/17/18	8/17/18	0.50	6.00	HAAS 5 Axis		JS 18-09-10
120	QC	8 pcs	8/17/18	8/17/18	0.00	0.00	QC2 Machining-2		JS 18-09-11
130	QC	8 pcs	8/17/18	8/17/18	0.00	0.00	QC8 Machining-2		SA 18-09-11
140	HandFinish	8 pcs	8/17/18	8/17/18	0.00	0.67	HandFinish1		SA 18-09-11
150	QC	8 pcs	8/17/18	8/17/18	0.00	0.00	QC7-5		DA6 SEP 18 2018 68
180	Packaging	8 pcs	8/17/18	8/17/18	0.00	0.00	Packaging3-2	GA	SEP 18 2018 9-89
190	QC21-SA	8 Ea	8/17/18	8/17/18	0.00	0.00	QC21	6A	SEP 18 2018 9-89

Part Op 90 - Cut Blank to 4.875"

Descriptions: 110 - 1-Machine per folio FC024. DWG REV: _____ FOLIO REV: _____ 2- Deburr and break all sharp edges.

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6B3.500X03.500	6061-T6 Bar 3.5" X 3.5" (Cut To 6 ft)	3.2560 ft (.407 ea)	90-Start up Operation	3029778 5109110

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M6061T6B3.500X03.500	3	13	0

Part Specifications

Specifications could not be found.



Dart Aerospace Ltd.
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Plex 8/9/18 9:42 AM Dart.lajeunesse.marie

Container No: S109113



Part: D5499-1

Job No: 181806

Serial No/Batch: S109113

Revision: B

Inspector:

Exp Date:

Instructions: Various STC's

Date: 09/10/18

DART AEROSPACE LTD		Work Order: 181806
Description: AFT Bracket Mount		Part Number: D5499-1
Inspection Dwg: D5499 Rev: B		Page 1 of 1

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
R.25	+/- .030	.250	✓		Rad gauge	
2.65	+/- .030	2.648	✓		SLIO	Vern
4.66	+/- .030	4.655	✓		"	
.623	+/- .010	.621	✓		"	
.13 X 45°	+/- .030	.125	✓		"	
Ø.191	+ .005/- .001	.193	✓		"	
R.13	+/- .030	.125	✓		Rad gauge	
.760	+/- .005	.7598	✓		Height gauge	
.80	+/- .030	.798	✓		SLIO	Vern
R.13	+/- .030	.125	✓		Rad gauge	
.69	+/- .030	.690	✓		SLIO	Vern
.33	+/- .030	.330	✓		"	
R.13	+/- .030	.125	✓		Rad gauge	
R.42	+/- .030	.420	✓		"	
1.50	+/- .030	1.496	✓		SLIO	Vern
Ø 1.245	+ .000/- .010	1.242	✓		SLIO	Mic
1.50	+/- .030	1.500	✓		SLIO	Vern
1.337	+/- .010	1.339	✓		Height gauge	
3.506	+/- .010	3.504	✓		"	
R.13	+/- .030	.125	✓		Rad gauge	
.80	+/- .030	.797	✓		SLIO	Vern
.343	+ .005/- .000	.345	✓		"	
1.92	+/- .030	1.9175	✓		"	
2.49	+/- .030	2.486	✓		"	
.40	+/- .030	.397	✓		"	
.623	+/- .010	.621	✓		Height gauge	
Ø.191	+ .005/- .001	.193	✓		SLIO	Vern
1.250	+ .010/- .000	1.250	✓		Height gauge	
.80	+/- .030	.795	✓		SLIO	Vern
Ø.257	+ .006/- .001	.258	✓		"	

Measured by: DAS	Checked by: JL	QC Inspector:
Date: 18-09-09	Date: 18-9-11	Date:

Engineering Approval: (If necessary)	Date:
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Rev	Date	Change	Revised by	Approved
B	14.07.31	New Issue	KJ	